

Date: Tuesday, 09/09/2008 1:20:39 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARMREST ASSEMBLY  
 Job Number : 41919  
 Estimate Number : 13346  
 P.O. Number :  
 This Issue : 09/09/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 39472  
 Written By : U  
 Checked & Approved By : U  
 Comment : Est Rev:A 08-05-26 new issue DD verified by:ec  
 Est Rev:B 08-07-22 revB as per dwg verified by:EC

Part Number : D3780041  
 Drawing Number : D3780 PRELIM 08.09.09  
 Project Number : N/A  
 Drawing Revision : PRELIM  
 Material :  
 Due Date : 16/09/2008 Qty: 1 Um: Each

PRELIMINARY ISSUE

POSITIVE  
RECALL

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D3696041	Arm Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Tube Assembly  
 batch: B40741 (1) 08.09.09

3.0	D3781041	Cushion Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Cushion Assembly  
 batch: B40732 (1) 08.09.09

4.0	D37853	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Bracket B41256 (1) 08.09.09  
 batch: B41256

5.0	AN96010L	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Washer H105743 (2) 08.09.09  
 batch: H105743

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 09/09/2008 1:20:39 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMREST ASSEMBLY

Job Number: 41919

Part Number: D3780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Nut

batch: M108701

(3)

08.09.09 *h*

7.0

MS24693C273

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Screw

batch: M107344

(3)

08.09.09 *h*

8.0

MS24693C273

Screw

*5277* *08.09.09*



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Screw

batch: M108550

(3)

08.09.09 *h*

(PTC)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D3780

08.09.09 *h*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08.09.11* *08.09.09*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker as per dwg (see note 6) and Stock Location: \_\_\_\_\_

*00224A*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/02/19*

Job Completion



POSITIVE RECALL

EFFECTIVE 08.09.09 AUTH *h*





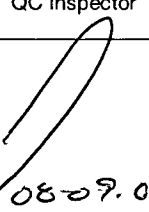
RELEASED 09.02.12 DATE *h*

*09.02.18*

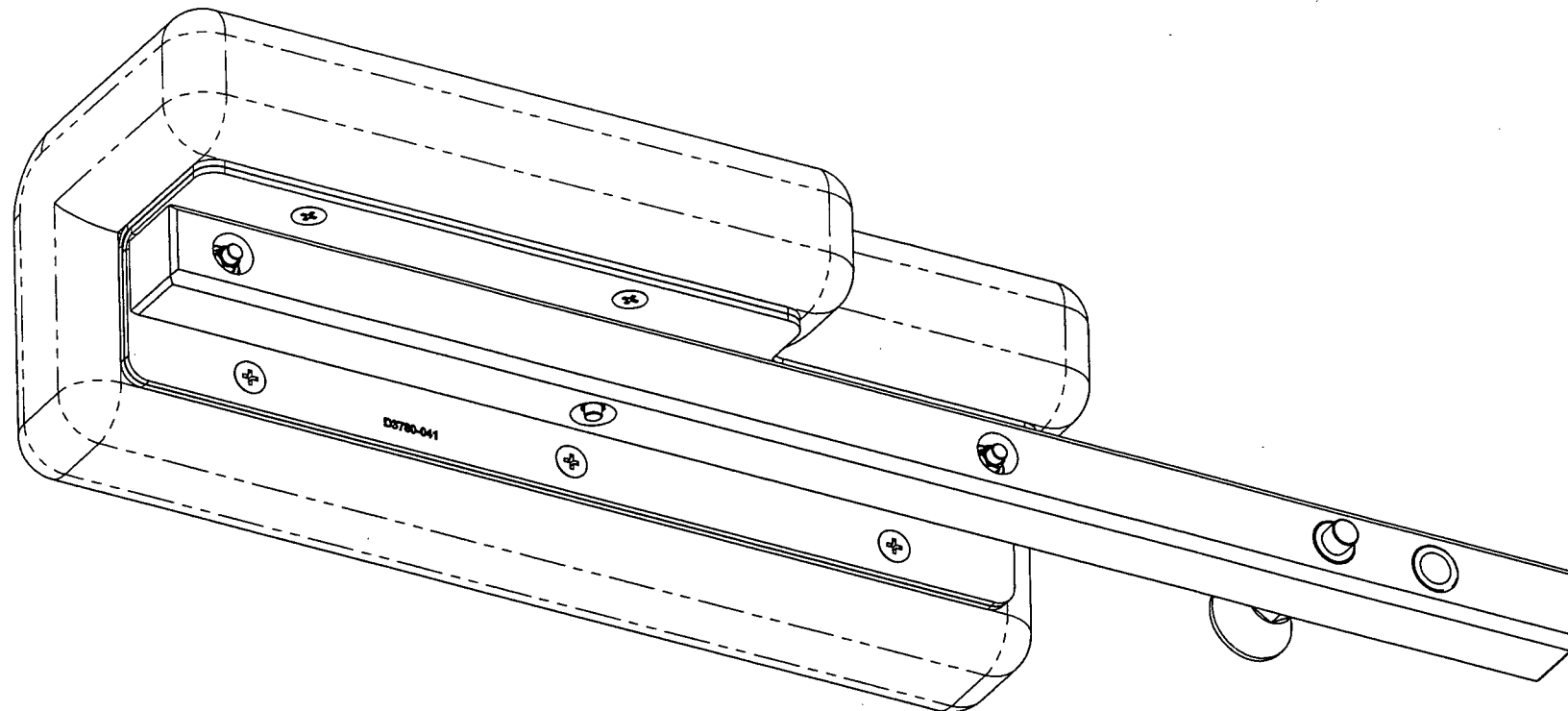
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3780-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>41919</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.01.09	8.0	USE MS24693S 277 IN LIEU OF MS24693C277	 08.01.09	ACCEPTABLE DEFERRED FOR THIS W/O.	 08.01.09	 08-09-09	 08.01.09	 08-09-09

NOTE: Date & initial all entries



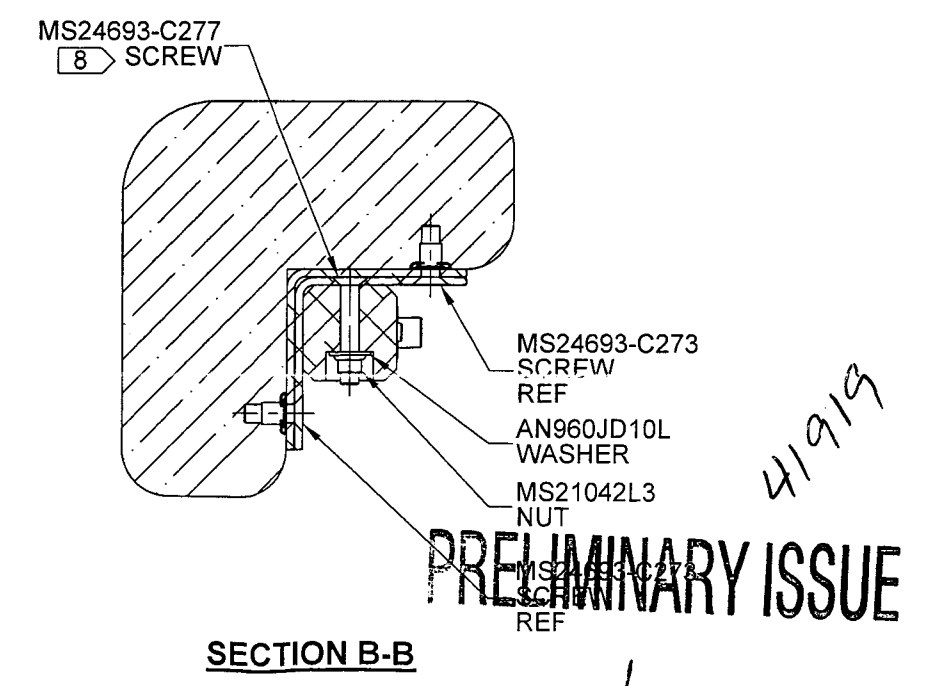
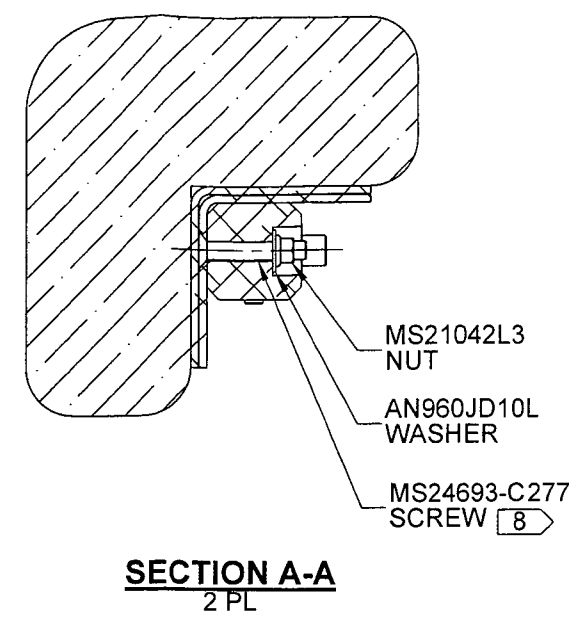
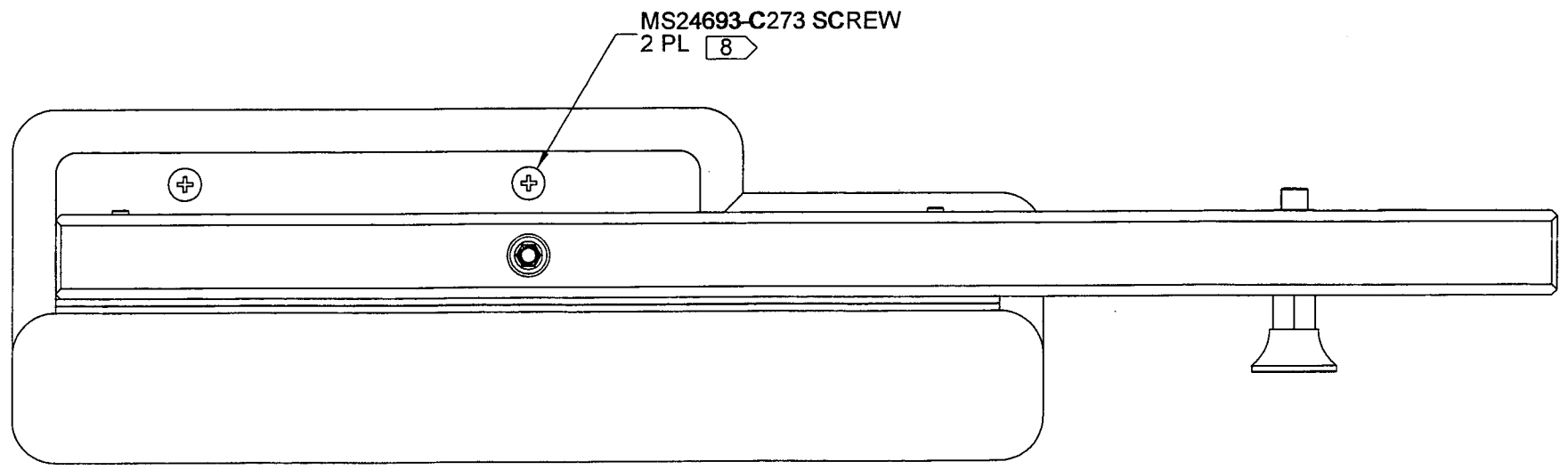
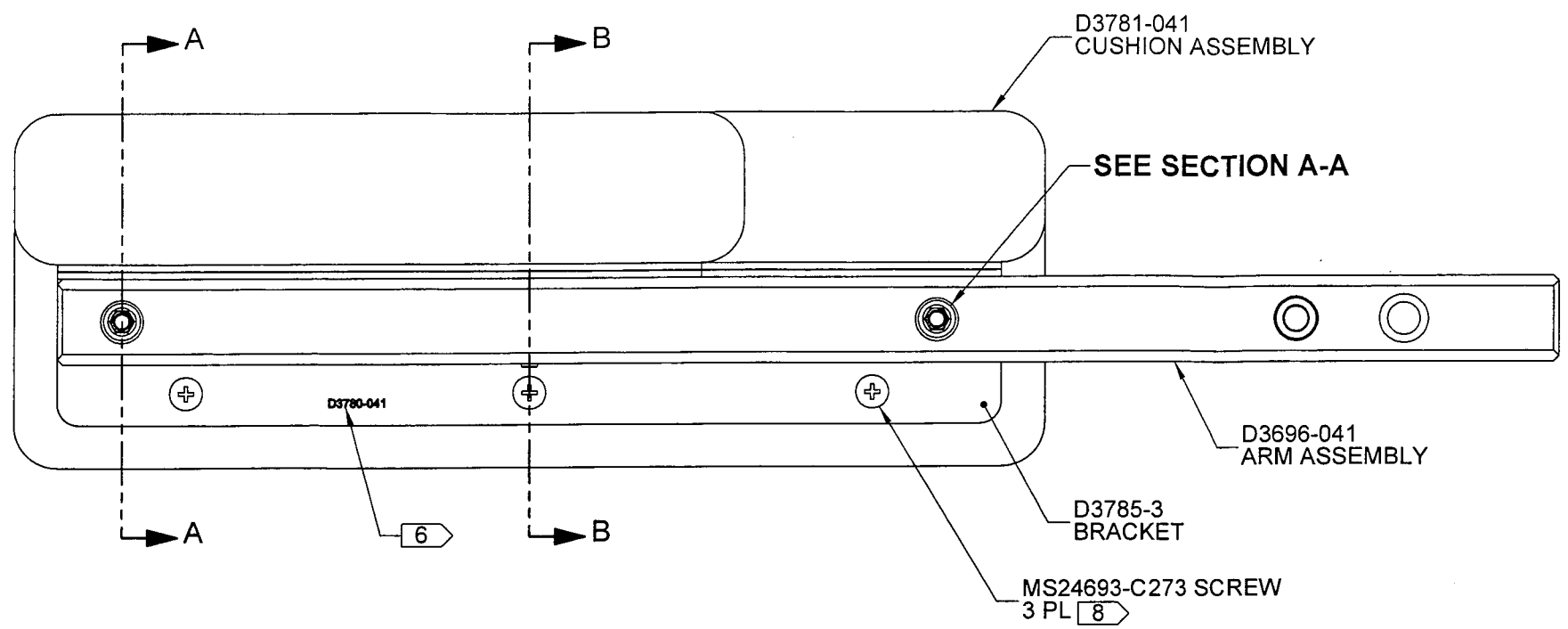
**D3780-041 ARMREST ASSEMBLY**

QTY -041	P/N	DESCRIPTION
X	D3780-041	ARMREST ASSEMBLY
1	D3696-041	ARM ASSEMBLY
1	D3781-041	CUSHION ASSEMBLY
1	D3785-3	BRACKET
3	AN960JD10L	WASHER
3	MS21042L3	NUT
5	MS24693-C273	SCREW
3	MS24693-C277	SCREW

41919  
**PRELIMINARY ISSUE**  
08.09.09

B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3780	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	08.07.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

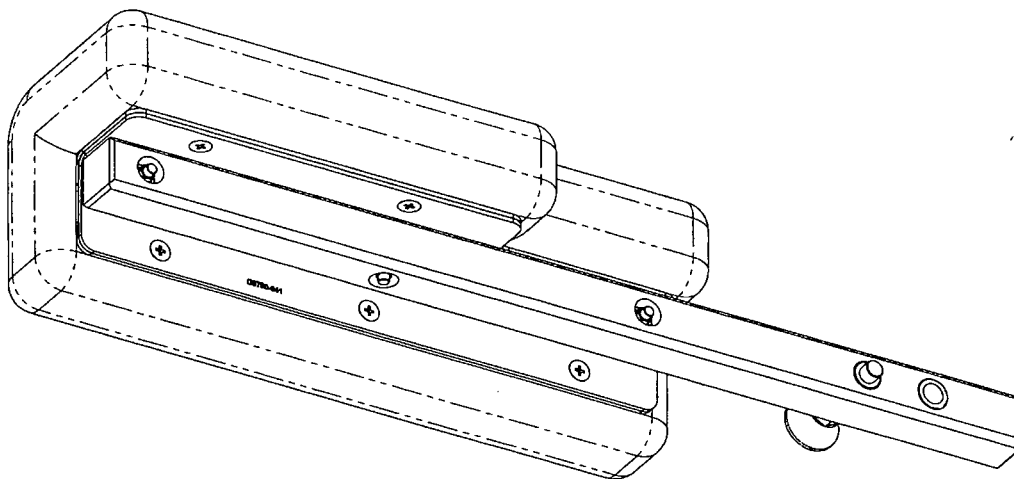
8 7 6 5 4 3 2 1



**D3780-041 NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 2.96 lbs
- 8) TORQUE SCREWS TO 20-25 in-lb.

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3780</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>ARMREST ASSEMBLY</b>	NTS
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**D3780-041 ARMREST ASSEMBLY**

41919

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1	D3781-041	CUSHION ASSEMBLY
1	D3785-3	BRACKET
3	AN960JD10L	WASHER
3	MS21042L3	NUT
5	MS24693-C273	SCREW
3	MS24693-C277	SCREW

UNDER REVIEW

ca. 01.14.16  
PDL BAW #CA-546

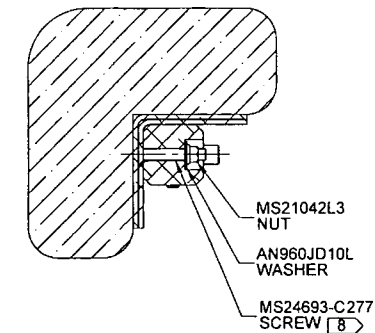
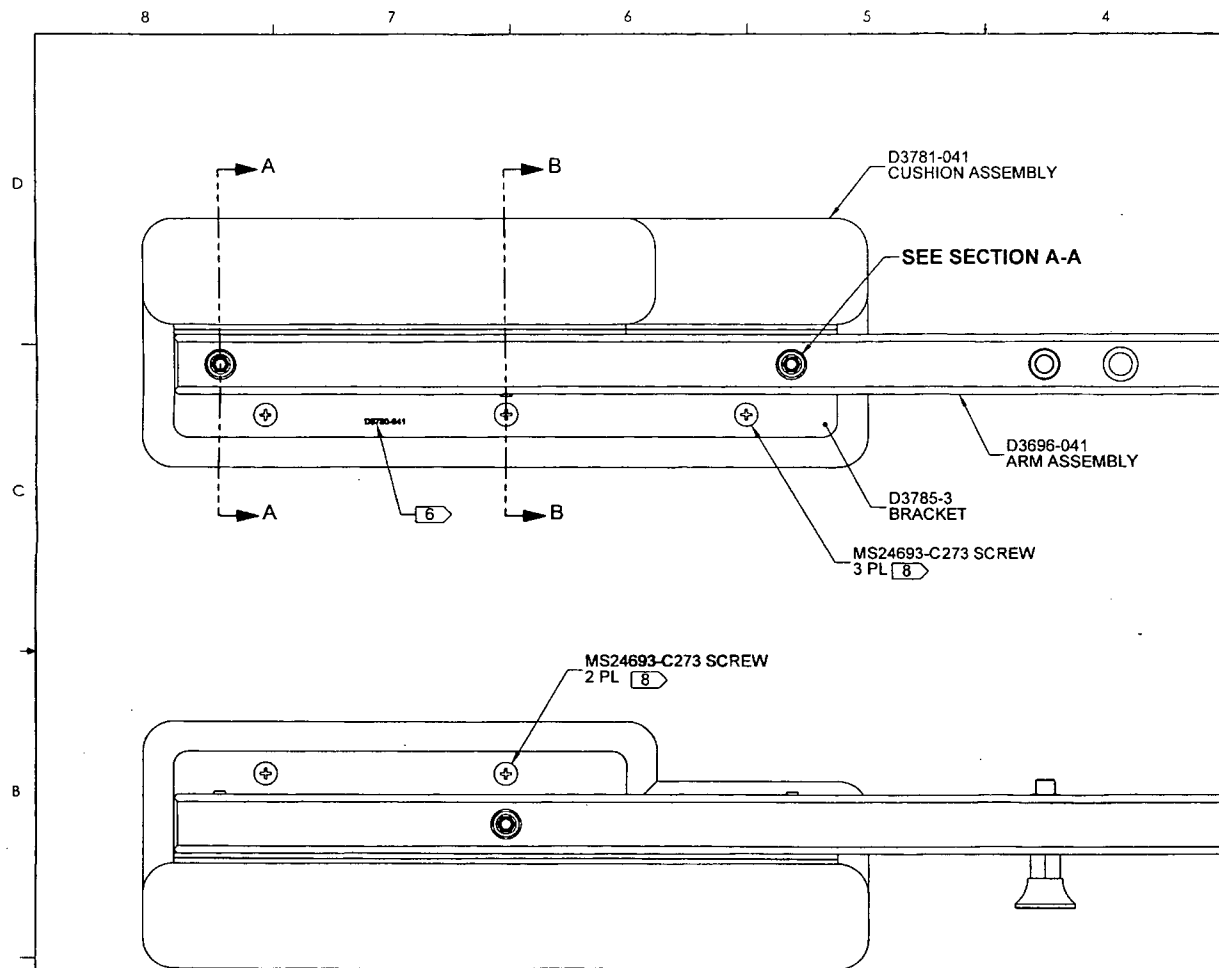
RELEASED  
09/01/14 MJD

B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.17		

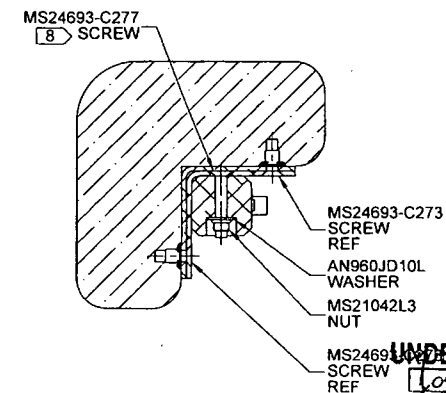
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3780  
TITLE ARMREST ASSEMBLY  
REV. B  
SHEET 1 OF 2  
SCALE NTS

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SECTION A-A  
2 PL



SECTION B-B

UNDER REVIEW  
09.01.14  
**RELEASED**  
09/01/14

**D3780-041 NOTES:**

- 1) MATERIAL: NONE
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3780</b>	REV. B
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		<b>ARMREST ASSEMBLY</b>	NTS
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